Split

D4857-044

B119765 *119765*

PRELIMINARY ISSUE



# Work Order ID 119765-1

*May-22-14 11:30:29 AM*

**Item ID:** D4857-044 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** ~~PRELIM~~ N/A **Stop** *NS2*

**Item Name:** Wiper Deflector Assembly, RH

**Start Date:** 5/22/14 **Start Qty:** ~~6.00~~ 5 *6* **Cust Item ID:**

**Required Date:** 5/23/14 **Req'd Qty:** 6.00 *6* **Customer:**

**Reference:** rework to new REV

**Run Start** *NR1*

**Approvals:** **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D4857 | ~~PD10~~ Rev. E | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| *110* | | | | | | 5 | | FF 14-08-06 | |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | Drill holes for D4857-4 as per dwg using DT10049 | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | (5) | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | | | | | | 5 | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | Touch up holes with primer as per dwg<br>SEE NOTE 4 ON SHEET 6 FOR PRIMER<br>A/R PRIMER BATCH: 128987 | | | | | | | | |

DAS 16 9-89 14/12/07

DAS 38 9-89 14/08/07

DAS 41 9-89 14-8-9

**Item ID:** D4857-044 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** ~~PRELIM~~ N/A REV **Stop** *NS2*
**Item Name:** Wiper Deflector Assembly, RH

**Start Date:** 5/22/14 **Start Qty:** 6.00 *6* **Cust Item ID:**
**Required Date:** 5/23/14 **Req'd Qty:** 6.00 *6* **Customer:**
**Reference:** rework to new REV

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 140 | QC14- Inspect Spray Paint | 0.00 | | | | (5) | | | DAS 38 9-89 14/08/11 |
| *140* QC Quality Control | Memo | 0.00 | | | | | | | |
| 150 | | 0.00 | | | | 5 | | FF 14-08-14 | |
| *150* Small Fab Small Fab | Memo<br>GLUE GASKET AS PER DWG<br>~~3M 1300/1300L ADHESIVE BATCH:~~<br>USING DOW CORNING 736 ADHESIVE. MF<br>B# M120589 | 0.00 | | | | | | | |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | (5) | | DAS 16 9-89 N/08/14 | DAS 38 9-89 14/08/14 |
| *160* QC Quality Control | Memo | 0.00 | | | | | | | |

## Work Order ID 119765

*May-22 14 11:30:29 AM*

*119765*

**Item ID:** D4857-044
**Revision ID:** ~~PRELIM~~ n/a
**Item Name:** Wiper Deflector Assembly, RH

**Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

**Start Date:** 5/22/14 **Start Qty:** 6.00 *6*
**Required Date:** 5/23/14 **Req'd Qty:** 6.00 *6*

**Cust Item ID:**
**Customer:**

**Reference:** rework to new REV

**Run Start** *NR1* **Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 170 | Identify as per dwg & Stock Location:_____ | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

STOCK Sub 8/19

MCJ 14-08-19

MF 14-8-13

POSITIVE RECALL
EFFECTIVE 14.0522 AUTH
RELEASED _____ DATE _____

Rev. E

# Picklist Print



*May-22-14 11:30:29 AM*

**Work Order ID:** 119765 *119765*

**Parent Item:** D4857-044 *D4857-044*

**Parent Item Name:** Wiper Deflector Assembly, RH

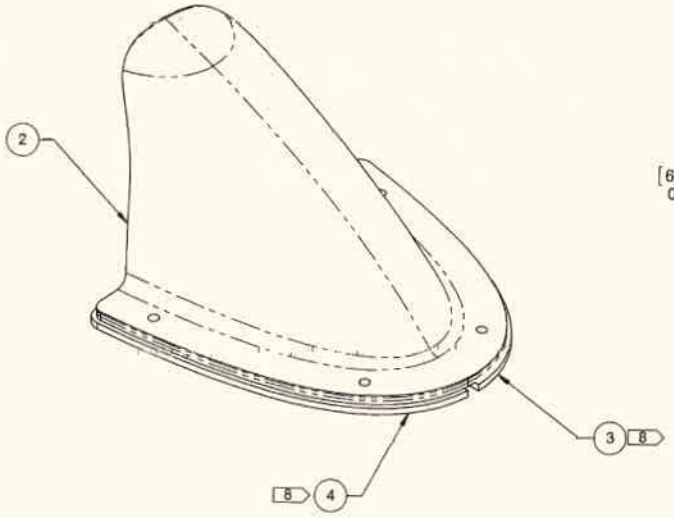
**Start Date:** 5/22/14 **Required Date:** 5/23/14

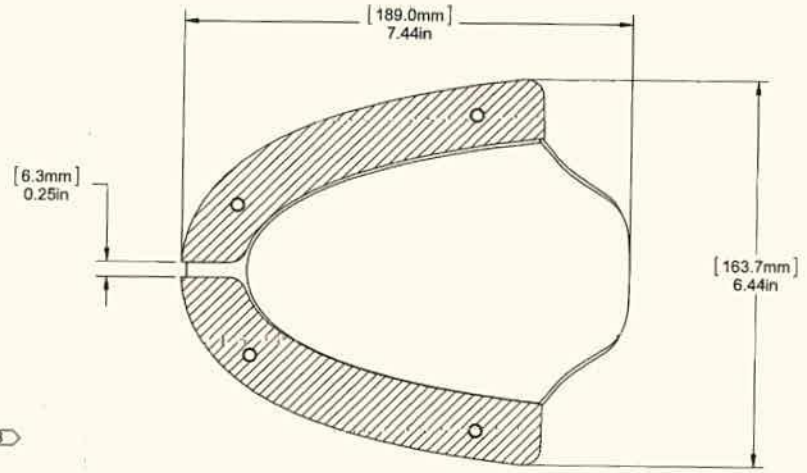
**Start Qty:** 6.00 **Required Qty:** 6.00

**Comments:** IPP REV:A 14.05.21 REV.PD10 DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D4857-1 | | Manufactured | No | | | | Each | 12.0000 | | 6 | | | |
| *D4857-1* | | | | | | | | | ** | | FF | 14-05-14 | |
| WiperDeflector | | | | | | | | | | | | | |
| | | | | **Location** | | | **Loc Qty** | | **Loc Code** | | | | |
| | | | | ST228 | | | 12 | | | | | | |
| | | | | | 109193 | | 2 ✓ | | | 4 | | | |
| | | | | | 109253 | | 10 | | | 3 | | | |
| D4857-M | | | | | | | | | | | | | |
| D5117-5 | | Manufactured | No | 123170 | | | Each | 0.0000 | | 6 | | | |
| *D5117-5* | | | | | | | | | ** | 5 | FF | 14-05-14 | |
| Gasket | | | | | | | | | | | | | |
| D5117-7 | | Manufactured | No | 123171 | | | Each | 0.0000 | | 6 | | | |
| *D5117-7* | | | | | | | | | ** | 5 | FF | 14-05-14 | |
| Gasket | | | | | | | | | | | | | |

| ITEM | QTY -044 | P/N | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4857-044 | WIPER DEFLECTOR ASSEMBLY, RH |
| | | | |
| 2 | 1 | D4857-4 | WIPER DEFLECTOR RH |
| 3 | 1 | D5117-5 | GASKET |
| 4 | 1 | D5117-7 | GASKET |




**D4857-044 WIPER DEFLECTOR ASSEMBLY, RH**

RELEASED
2014 -06- 11

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
E 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-044, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
7) WEIGHT: 0.38 lbs (0.17 kg)
8) BOND D5117-5/-7 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

APPROVED

| | |
|---|---|
| DESIGN | DW |
| DRAWN | RF |
| CHECKED | VS |
| MFG. APPR. | JFS |
| APPROVED | MP |
| DE APPR. | DS |
| DATE | 14.06.05 |

**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4857 REV. E
SHEET 2 OF 7
TITLE WIPER DEFLECTOR SCALE NTS

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DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

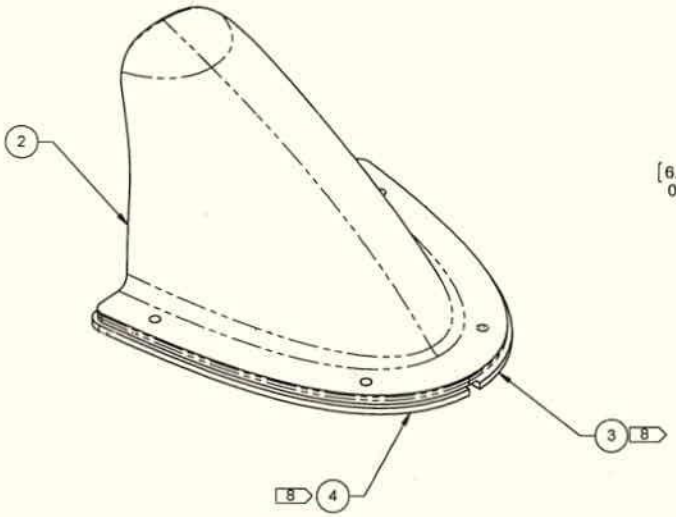
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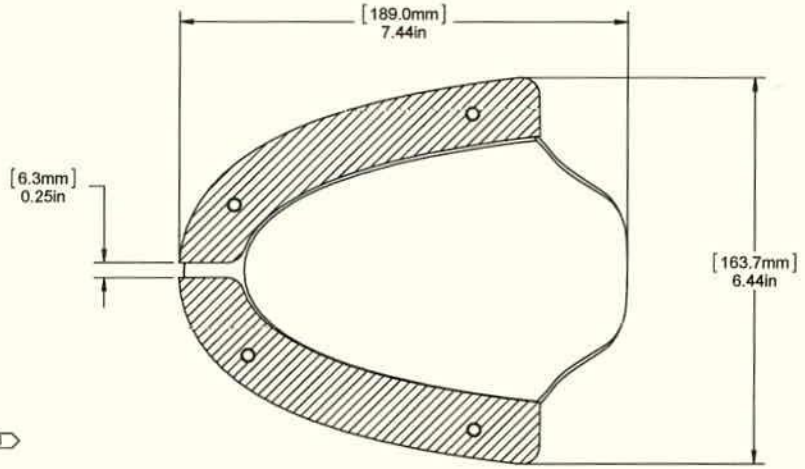
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_____

PRELIMINARY ISSUE

| ITEM | QTY -044 | P/N | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4857-044 | WIPER DEFLECTOR ASSEMBLY, RH |
| | | | |
| 2 | 1 | D4857-4 | WIPER DEFLECTOR RH |
| 3 | 1 | D5117-5 | GASKET |
| 4 | 1 | D5117-7 | GASKET |



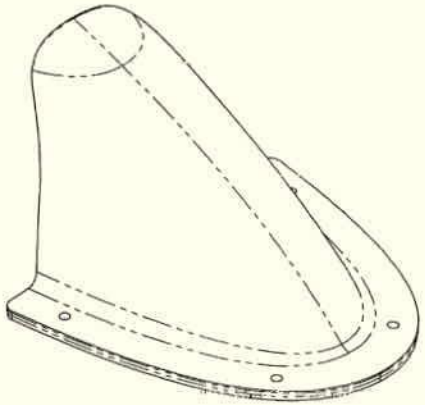

**D4857-044 WIPER DEFLECTOR ASSEMBLY, RH** △D

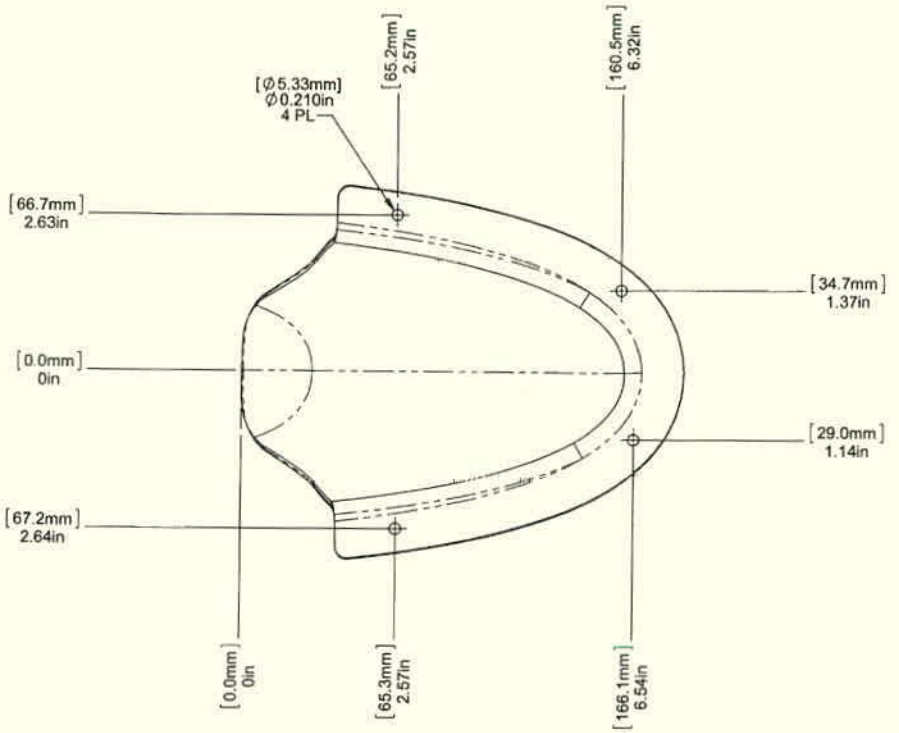
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-044, AGUSTA P/N "TBD", REVISION AND BATCH NUMBER AS PER QSI 044 METHOD 6.1
7) WEIGHT: 0.38 lbs (0.17 kg)
8) BOND D5117-5/-7 GASKET TO EDGE OF PART USING 3M 1300/1300L ADHESIVE

WORK IN PROGRESS

| | | |
|---|---|---|
| DESIGN | DW | DART AEROSPACE LTD |
| DRAWN | AK | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4857 REV. D |
| MFG. APPR. | | SHEET 2 OF 7 |
| APPROVED | | TITLE WIPER DEFLECTOR SCALE NTS |
| DE APPR. | DS | |
| DATE | 14.05.13 | |

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**D4857-4 WIPER DEFLECTOR, RH**

RELEASED
2014 -06- 11
MP

No 119765

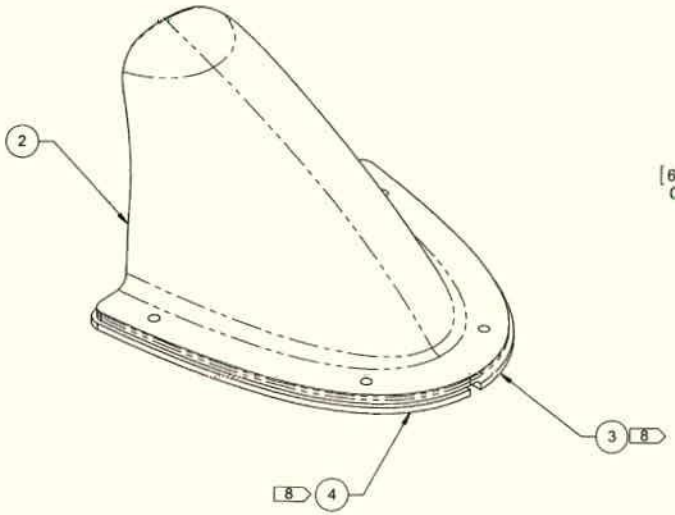
NOTES:
1) MATERIAL: MADE FROM D4857-M
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.24 lbs (0.11 kg)
8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-4-e.IGES

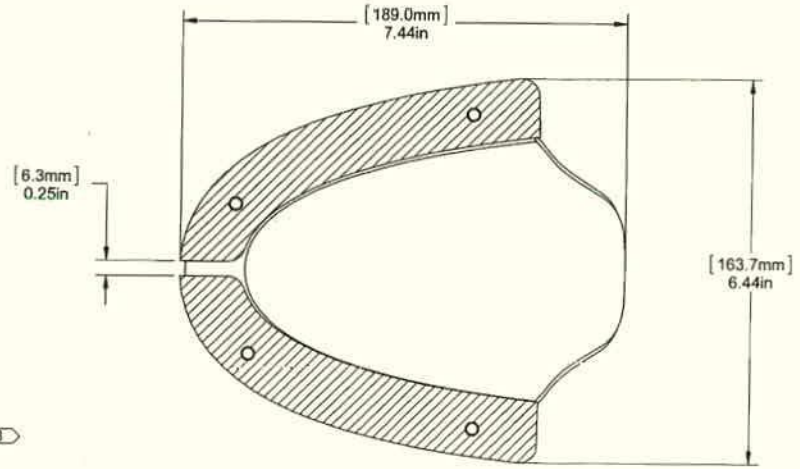
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| | | |
|---|---|---|
| DESIGN | DW | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | VS | DRAWING NO. D4857 REV. E |
| MFG. APPR. | JFS | SHEET 5 OF 7 |
| APPROVED | MP | TITLE WIPER DEFLECTOR SCALE NTS |
| DE APPR. | DS | |
| DATE | 14.06.05 | |

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| ITEM | QTY -044 | P/N | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4857-044 | WIPER DEFLECTOR ASSEMBLY, RH |
| | | | |
| 2 | 1 | D4857-4 | WIPER DEFLECTOR RH |
| 3 | 1 | D5117-5 | GASKET |
| 4 | 1 | D5117-7 | GASKET |




**D4857-044 WIPER DEFLECTOR ASSEMBLY, RH**

RELEASED
2014 -06- 11

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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7) WEIGHT: 0.38 lbs (0.17 kg)
8) BOND D5117-5/-7 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

APPROVED

| | | |
|---|---|---|
| DESIGN | DW | DART AEROSPACE LTD |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | VS | DRAWING NO. D4857 REV. E |
| MFG. APPR. | JFS | SHEET 2 OF 7 |
| APPROVED | MP | TITLE WIPER DEFLECTOR SCALE NTS |
| DE APPR. | DS | |
| DATE | 14.06.05 | |

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